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(54) VACUUM DIE CASTING DEVICE

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(57) Abstract:

PURPOSE: To prevent intrusion of a molten metal into an evacuating passage by providing a selector valve which opens and closes a passage between a cavity and the evacuator and a passage between the cavity and an injection cylinder sleeve in such a manner that the latter are closed while the former are open and the latter are opened while the former are closed.

CONSTITUTION: A plunger tip 5 is moved to the right to communicate a pouring hole 4 and the injection cylinder sleeve 3 and to accept the molten metal. The selector valve plug 10 is held in the right end position by the pressure of a damper member 11 by which a gate 7 is shut off from the cylinder 3 and is connected to the evacuating passage 9. The selector valve plug 10 is moved to the left when the plunger 5 moves to the left by the pressure of the molten metal. The gate 7 is then communicated with the cylinder 3 and shut off from the passage 9 to inject the molten metal into the cavity 1. The intrusion of the molten metal as well as the pulverized molten metal, gases, etc., into the passage 9 is obviated and the maintenance is facilitated.

